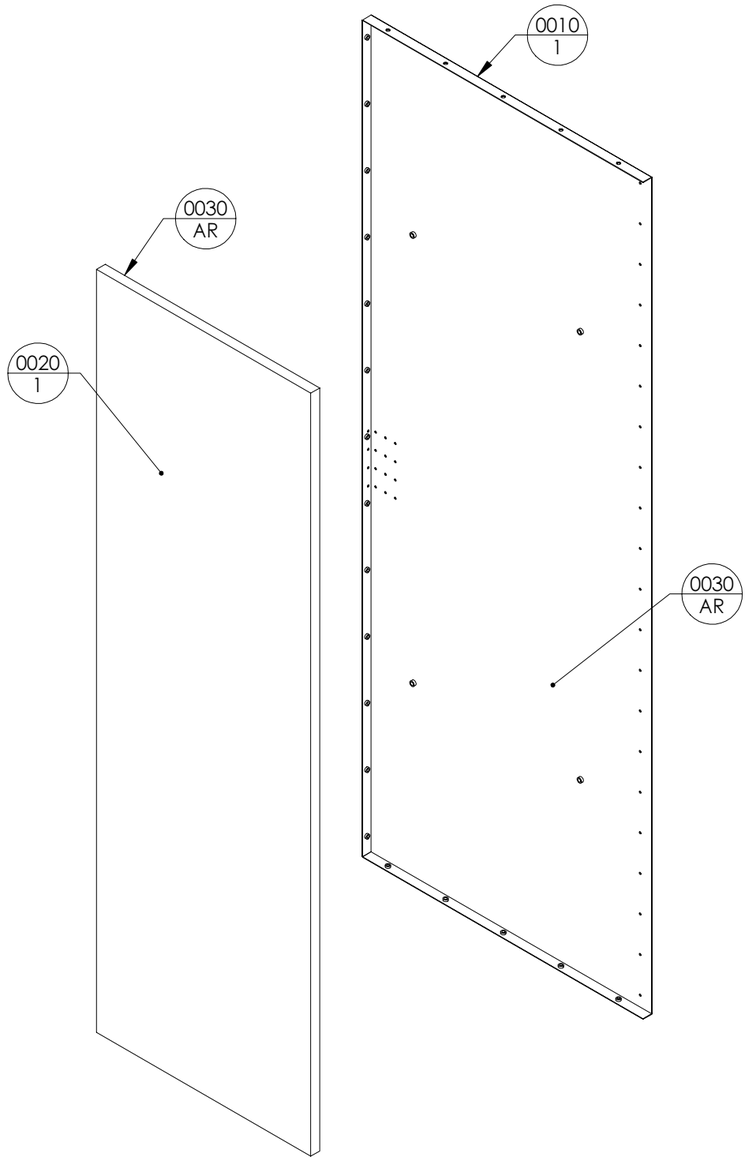
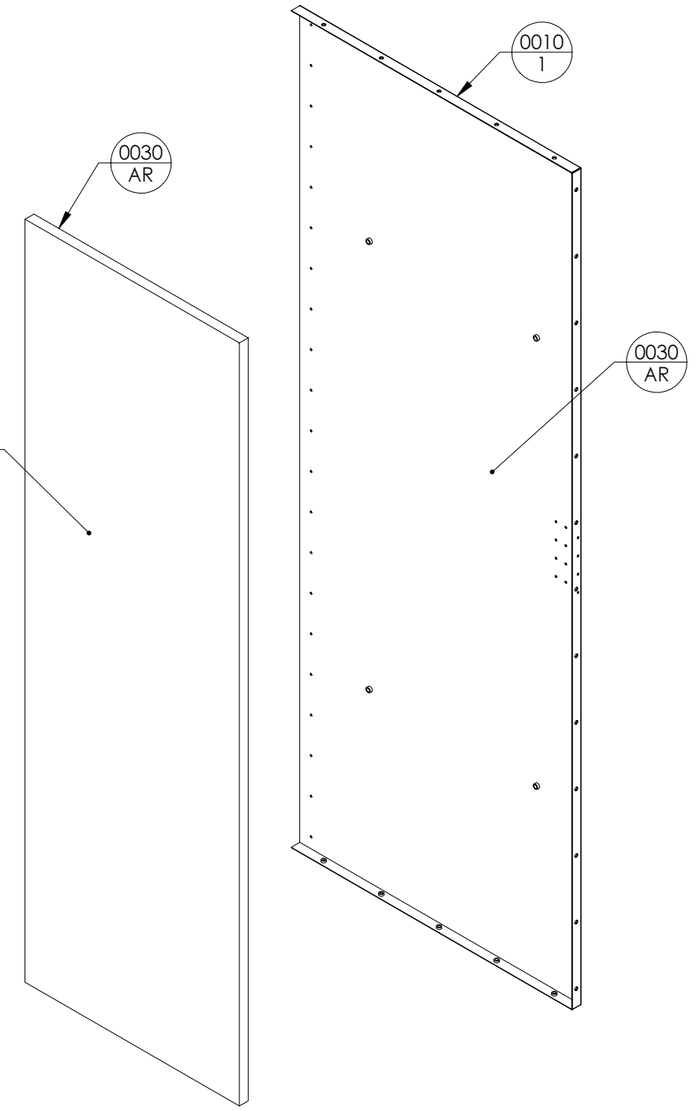
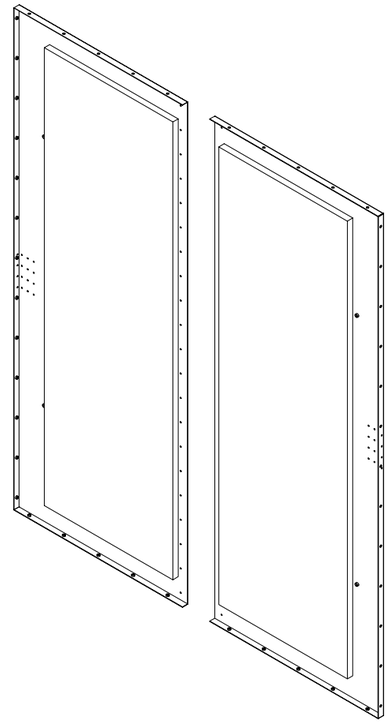
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LEFT SIDE



RIGHT SIDE



FOR ASSEMBLY INSTRUCTIONS
SEE SHEET 03

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D	E396	2001:OCT:18	I.PRESS	D.HUBER
C	E103	2001:APR:17	D WOODBURN	P LAGODSKI

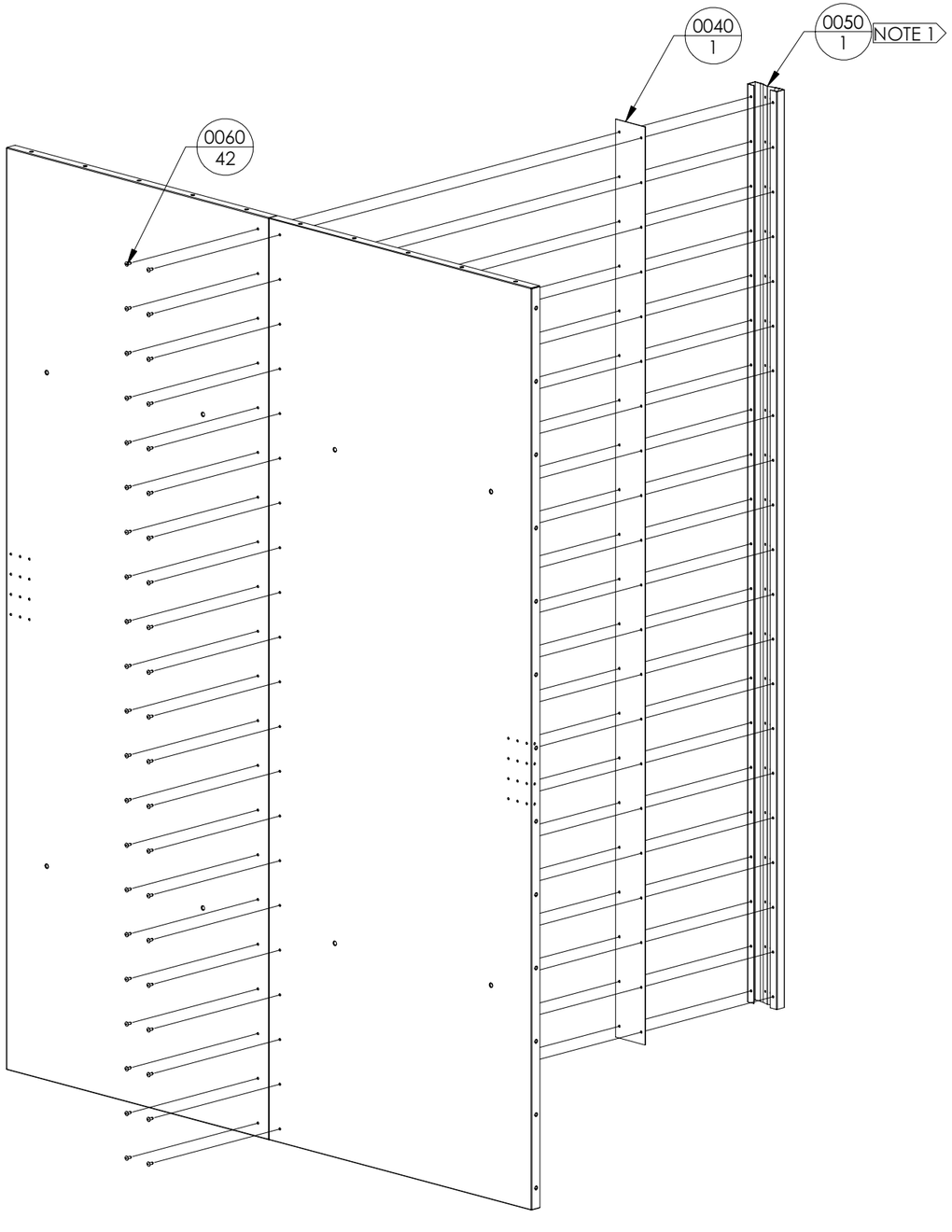
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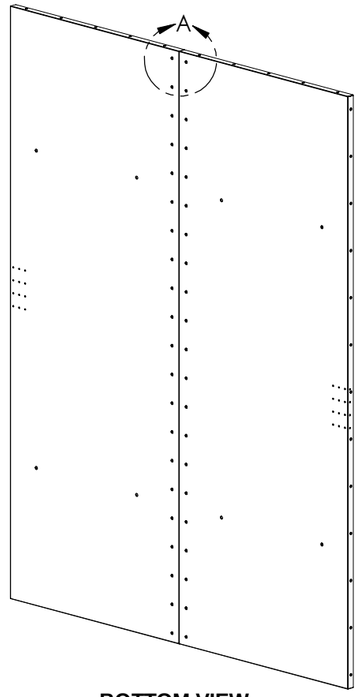
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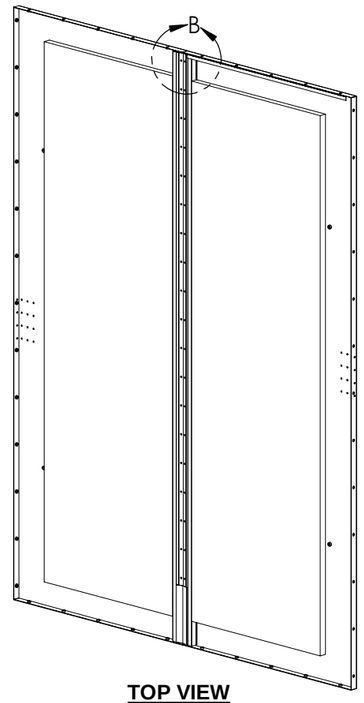
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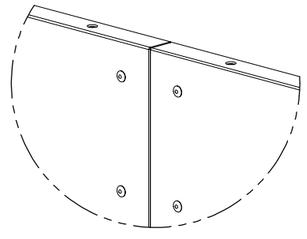




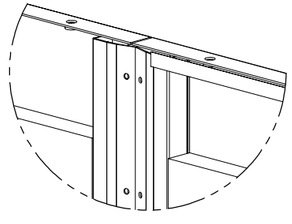
BOTTOM VIEW



TOP VIEW



DETAIL A
SCALE 1 : 5



DETAIL B
SCALE 1 : 5

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ASSEMBLY INSTRUCTIONS

1. RIVET SPLICE PLATE AND SPLICE CHANNEL TO LOWER SKIN PANELS. PLACE TOP SKIN PANEL OVER LOWER SKIN PANEL AND ENSURE THAT ALL HOLES LINE UP WITH PEMNUTS AND RIVET HOLES.

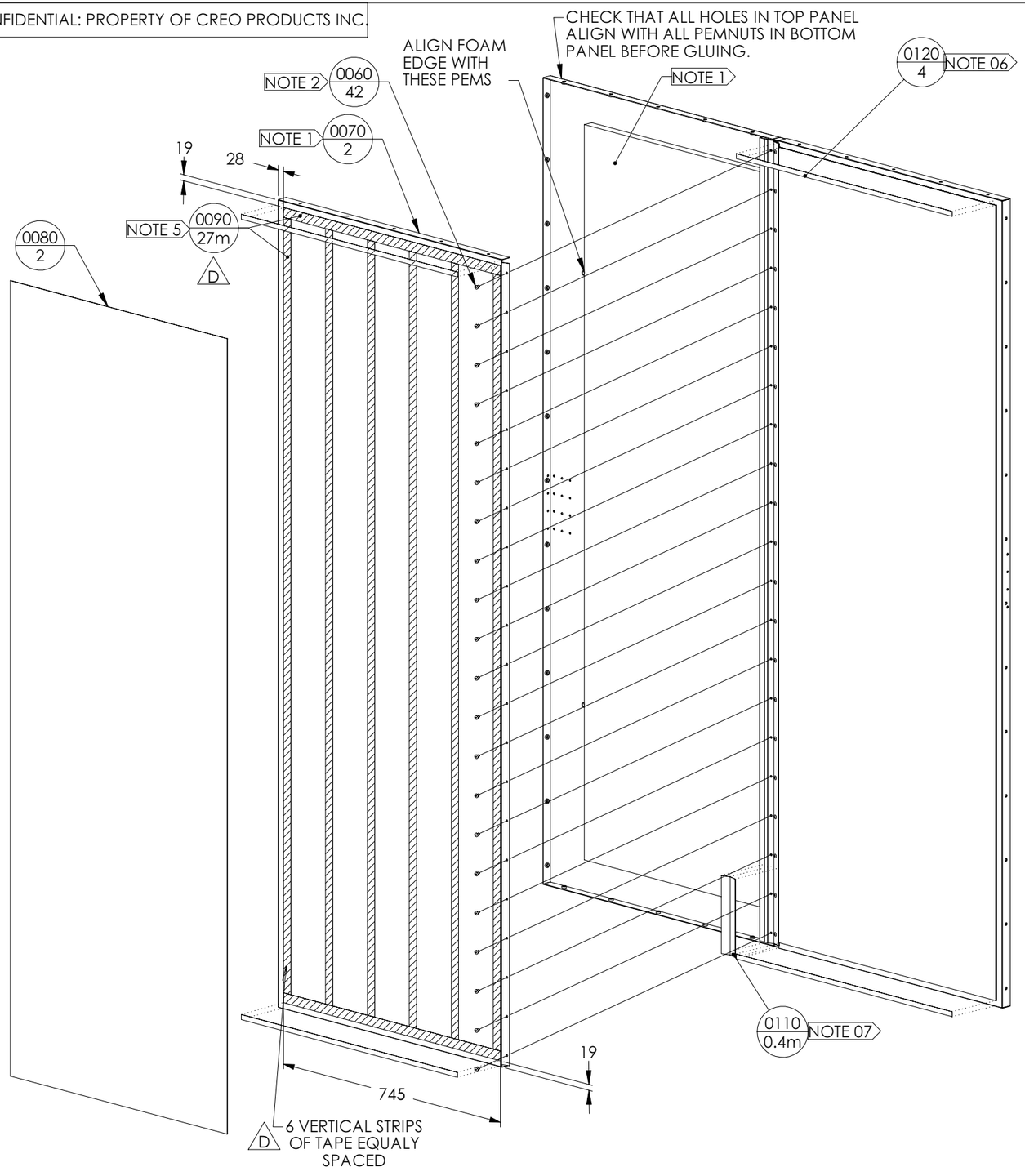
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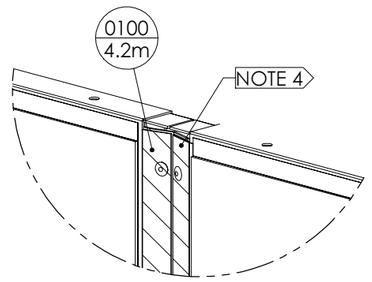
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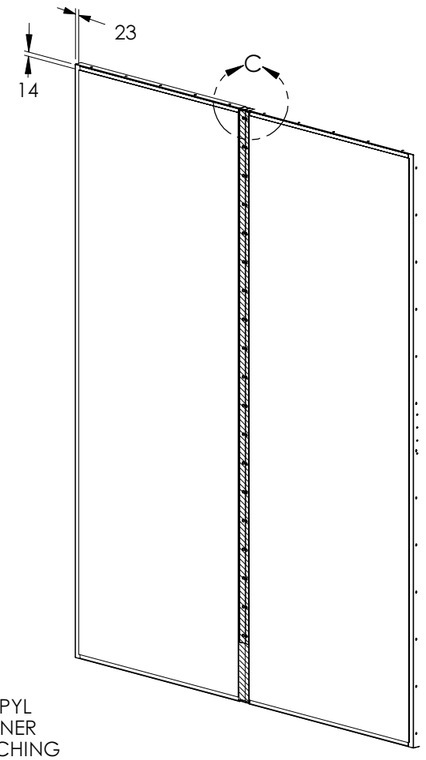
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DETAIL C



ASSEMBLY INSTRUCTIONS

1. CLEAN ALL MATING SURFACES WITH ISOPROPYL ALCOHOL. APPLY CEMENT [ITEM 0030] TO INNER SURFACES OF UPPER SKIN PANELS AND MATCHING FACE OF STYROFOAM SHEETS. ALLOW TO SET FOR 30 - 45 MINUTES BEFORE BRINGING PIECES TOGETHER. CENTER FOAM VERTICALLY AND ALIGN FOAM OUTER EDGE WITH PEMNUTS IN BASE [ITEM 0010 SHT 1].APPLY 9 Kg (20Lb) ROLLING PRESSURE FROM THE OUTSIDE INWARD OVER THE METAL SURFACE TO ENSURE PROPER CONTACT ADHESION.
2. RIVET CENTRE SPLICE SECTION TOGETHER. INSERT TWO SCREWS ON EACH SIDE OF THE ASSEMBLED PANEL TO PREVENT DELAMINATION STRESSING.
3. EXPLODED VIEW IS TYPICAL FOR BOTH SIDES. PIECE IS SYMMETRIC.
4. CUT UHMW ANTI-STATIC TAPE [ITEM 0100] TO LENGTH AND APPLY OVER RIVETS TO INNER EDGE OF SPLICE CHANNEL.
5. CUT DOUBLE-SIDED TAPE [ITEM 0090] TO SIZE OF ARBORITE PANEL AND APPLY AS SHOWN.
6. CUT SCALES AT 23mm AND 775mm. AFFIX SCALES TO TOP AND BOTTOM MARGINS (OFF ARBORITE) SUCH THAT THE 23mm MARK IS 23mm FROM THE CASSETTE CENTER LINE, FOUR PLACES.
7. CUT REFLECTIVE TAPE INTO TWO 200 mm LONG PIECES AND APPLY TO SIDES OF CENTER GROOVE AS SHOWN.

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